

Date Wednesday, 15/08/2007 4:08:58 PM
 User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Jot Number	: 33972	Part Number	: D412742013
Estimate Number	: 10366	Drawing Number	: N/A UNDER REVIEW
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2007	Drawing Revision	: N/A
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 03/09/2007
Previous Run	: 33971	Qty:	1
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev:A 05.10.13 New Issue KJ/JLM Est Rev:B 06-06-08 As per DSI9336 JLM		

Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	 KES 07-08-29
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003	 EP 07/09/12
2.0	33972A	FLOAT SKID ASSEMBLY	
		Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B <u>33972A</u>	
3.0	D2571	Saddle, Fwd, Out	 <i>EP</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2571 Saddle Fwd Outside <u>B32165</u>	
4.0	D2572	Saddle, Fwd, In	 <i>EP</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2572 Saddle Fwd Inside <u>B31720</u>	 <i>EP 07/09/10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33972

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D2573	Saddle, Aft, Out
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2573 Saddle Aft Outside B31721 -	
6.0	D2574	Saddle, Aft, In
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2574 Saddle Aft Outside B32168 -	
7.0	D2747	Set Screw
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	4 D2747 Bolt B33470 -	
8.0	D2876	Saddle Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D2876 Saddle Spacer B31227 -	
9.0	D2877	Saddle Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D2877 Saddle Spacer B32104 -	
10.0	D34031	Bushing
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	16 D3403-1 Bushing B33786 61/9/12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33972

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :	Signature	Barcode	Comment
11.0	D34033	Bushing			
					Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	8 D3403-3	Bushing			<u>632889</u>
12.0	D3405041	Lug Assembly			
					Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	1 D3405-041	GHW Lug			<u>B32890</u>
13.0	D3405043	Lug Assembly			
					Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	1 D3405-043	GHW Lug			<u>1032891</u>
14.0	AN4C6A	Bolt			
					Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	16 AN4C6A	Bolt			<u>M104603</u>
15.0	AN4C46A	BOLT			
					Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	4 AN4C46A	Bolt			<u>M19528</u>
16.0	AN4C52A	BOLT			
					Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
		Pick:			
	Qty Part Number	Description			Batch
	8 AN4C52A	Bolt			<u>M10034020 M195126 Epoxy 9/10/08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/12	# 11.0	Parts Found in Kit with no P/n# and no Batch # R.C. Hammancraze	J Initial	Write Down Proper Batch and P/n#'s down.	GP 07/09/12	E 07/09/12	osmark	EP 07/09/12

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33972

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

17.0 AN6C12A BOLT



EP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN6C12A	Bolt	<u>M104289</u>

18.0 AN960C416L WASHER



EP



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
32	AN960C416L	Washer	<u>M104936</u>

19.0 AN960C616L WASHER



EP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960C616L	Washer	<u>M18822</u>

20.0 AN960C716L WASHER



EP



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	AN960C716L	Washer	<u>M104093</u>

21.0 MS210434 Nut



EP



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
29	MS21043-4Nut		<u>M105115</u>

EP 07/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33972

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
22.0	NAS1515H4L	WASHER
<p>Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)</p> <p>Pick:</p> <p>Qty Part Number Description Batch 32 NAS1515H4L Washer M105211</p>		
23.0	NAS1515H6L	WASHER
<p>Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>Pick:</p> <p>Qty Part Number Description Batch 8 NAS1515H6L Washer M18918</p>		
24.0	NAS1515H7L	WASHER
<p>Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)</p> <p>Pick:</p> <p>Qty Part Number Description Batch 16 NAS1515H7L Washer M100727</p>		
25.0	D3407041	Tow Ring
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)</p> <p>Pick:</p> <p>Qty Part Number Description Batch 1 D3407-041 TOW RING 032892</p>		
26.0	D34173	Washer
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Pick:</p> <p>Qty Part Number Description Batch 2 D3417-3 WASHER 633519</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:08:59 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33972

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

27.0	D34561	washer
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3456-1	WASHER	633276



28.0	AN4C7A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

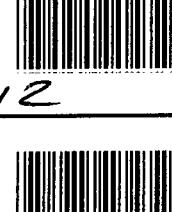
Batch: M101427



29.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS



30.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: NEW



31.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date Wednesday, 15/08/2007 4:09:14 PM
 User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 33972A	Part Number	: D412742043
Estimate Number	: 10756	Drawing Number	: D3391 REV F
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2007	Drawing Revision	: F
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 03/09/2007
Previous Run	: 33971A	Qty:	1
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG003
2.0	D3391023	Mid Tube Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch <u>B 32239</u>
3.0	D3391025	Aft Tube Assembly
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) pick: Qty Part Number Description Batch <u>B 33645</u>
4.0	D35641	WEARSHOE
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <u>B 33243</u> <u>m.f 07/08/20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

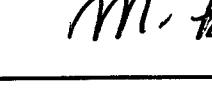
Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33972A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D35643	WEARSHOE  Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <u>B33764</u> 
6.0	D35645	WEARSHOE  Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: <u>B33802</u> 
7.0	D35661	GASKET  Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) GASKET Batch: <u>B33458</u> 
8.0	D35665	GASKET  Comment: Qty.: 1.00000 Each(s)/Unit Total : 1.00000 Each(s) GASKET Batch: <u>B33483</u> 
9.0	AN3C4A	BOLT  Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s) BOLT Batch: <u>M105143</u> 
10.0	AN3C6A	BOLT  Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) BOLT Batch: <u>M103693</u> 
11.0	AN3C7A	BOLT  Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) BOLT Batch: <u>M103668</u>   <u>07/08/20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33972A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch:

M10 5143

M-L

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M104161

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M1041989

Expiry date: 08-01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251

A/R Sikaflex-241/-291 M104989

Expiry date: 08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

M-L
07/08/21

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ex 01/08/31

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: PPP Rev: 33572 07/08/12
PPP Rev: 33572 07/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:09:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33972A

Part Number: D412742043

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
Dana 9/12

Job Completion



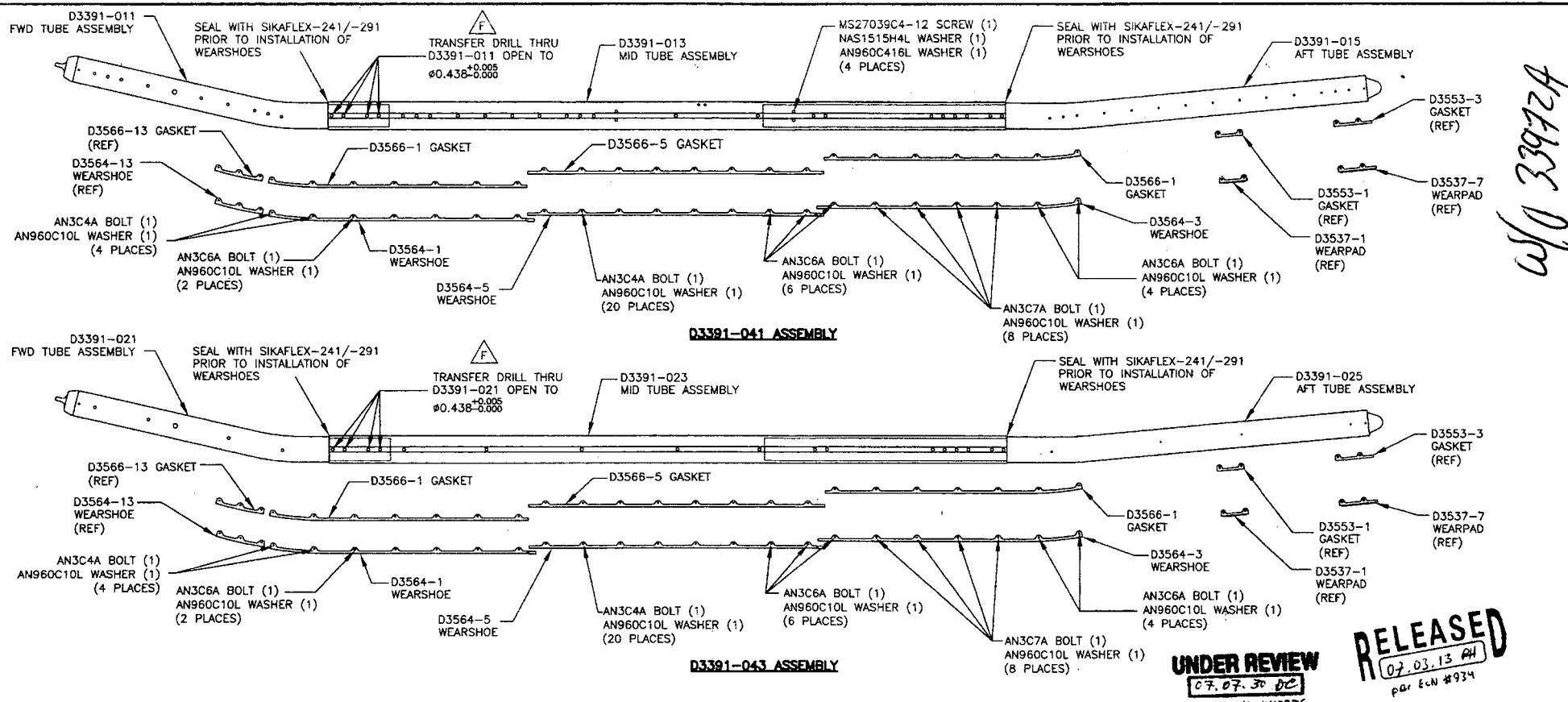
U 8-29-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
1	24	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (.0250-.0257) FOR WEARSHOE INSERTS. C'SINK .0391/.0425 x 100° AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

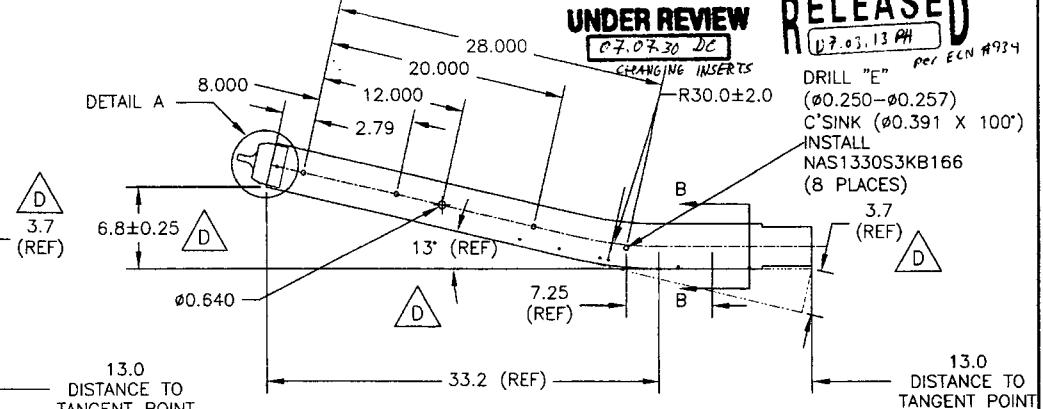
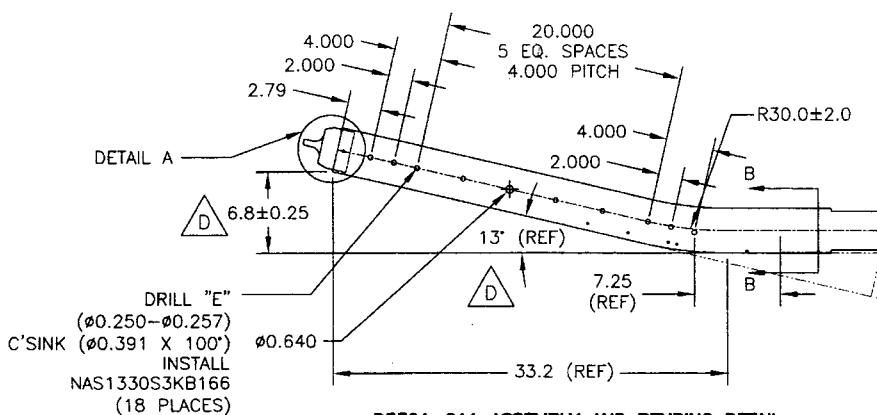
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	REV.
P4	A4	F
CHECKED	APPROVED	
		DRAWING NO.
		D3391
		SHEET 1 OF 5
DATE	TITLE	SCALE
07.01.18	412 FLOAT SKIDTUBE	NTS

RELEASER
07.03.13 AM
FBI E&N #934

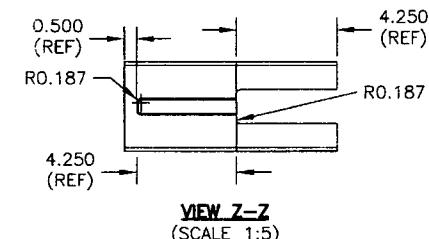
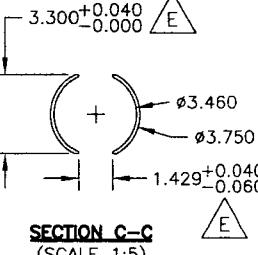
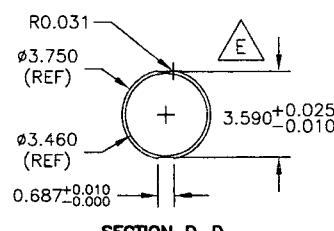
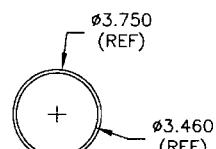
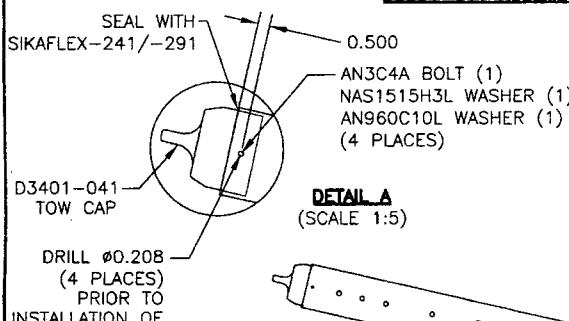
UNDER REVIEW

RELEASED
07.03.13 PH
per ECN #934



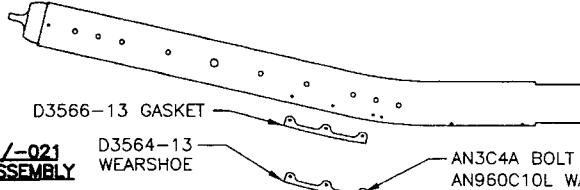
D3391-011 ASSEMBLY AND BENDING DETAIL

D3391-021 ASSEMBLY AND BENDING DETAIL



VIEW Z-Z (SCALE 1:5)

D3391-011/-021 WEARSHOE ASSEMBLY

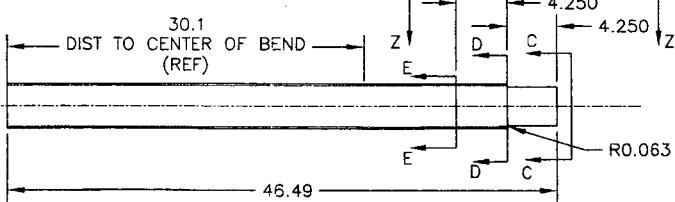


D3564-13 WEARSHOE

AN3C4A BOLT (1)
AN960C10L WASHER (1) (6 PLACES)

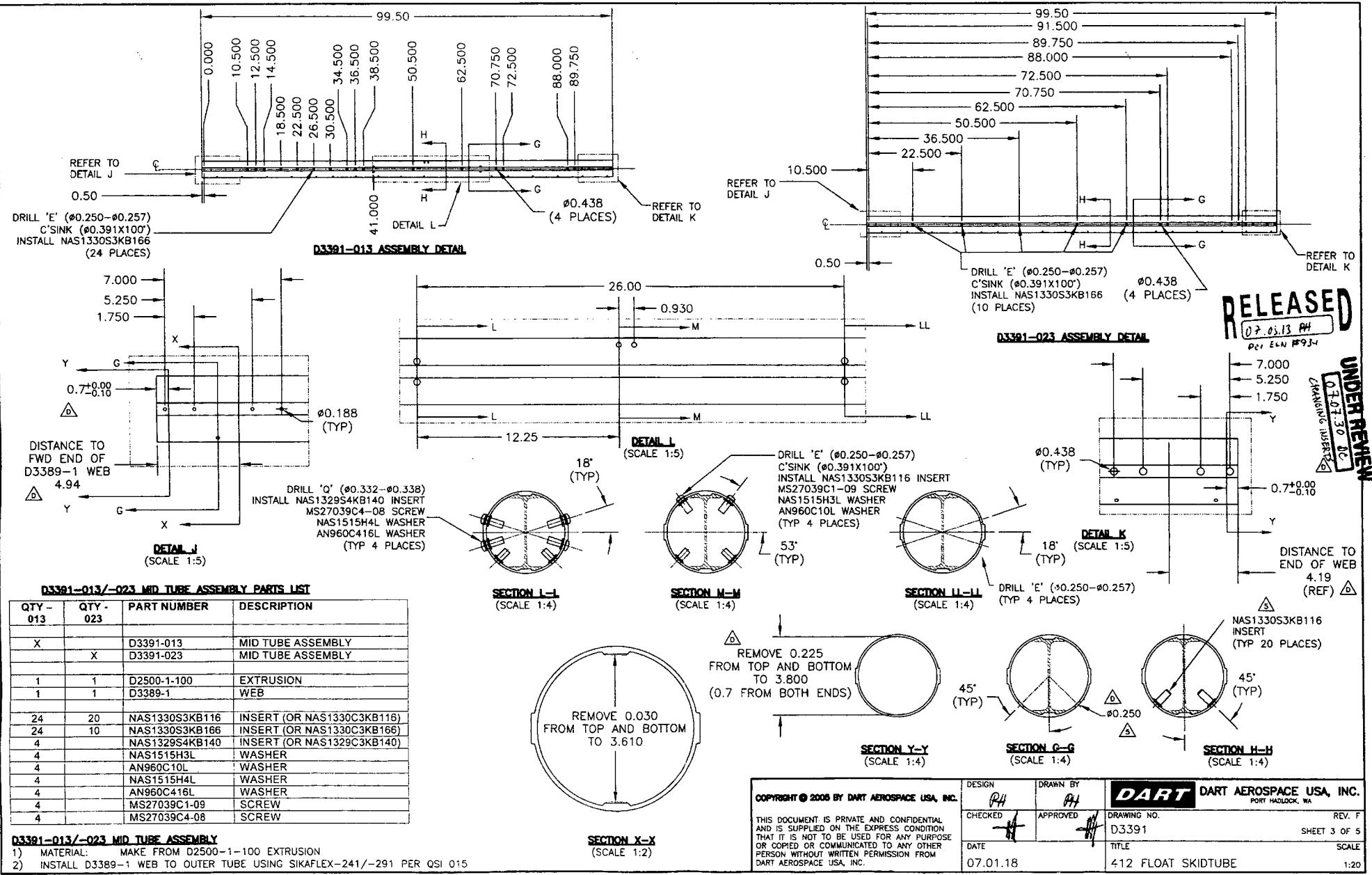
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)



D3391-1 DRILLING AND CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

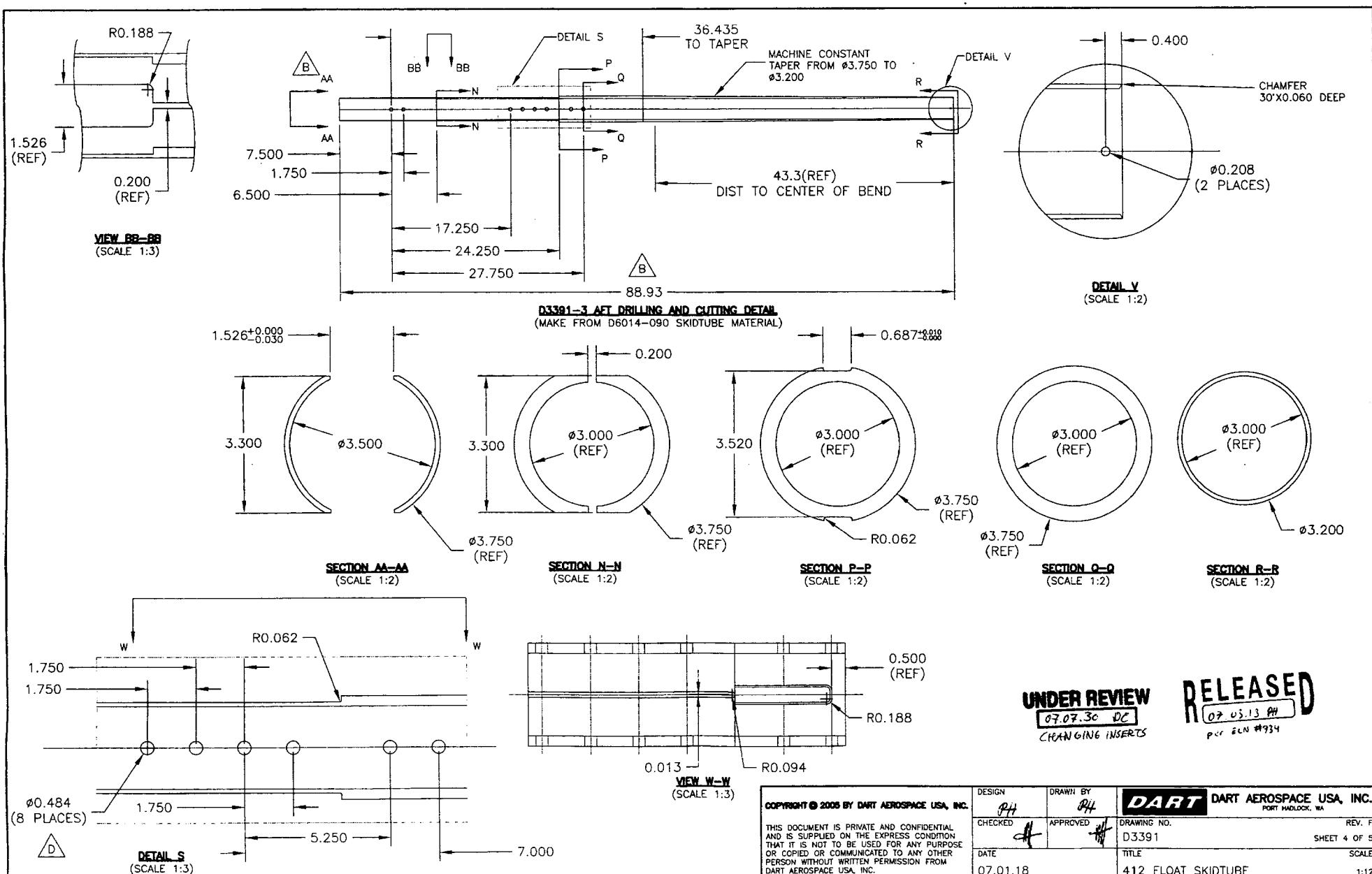
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE USA, INC. PORT HEDLOCK, WA
CHECKED /	APPROVED /	DRAWING NO. D3391	REV. F	
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SHEET 2 OF 5		

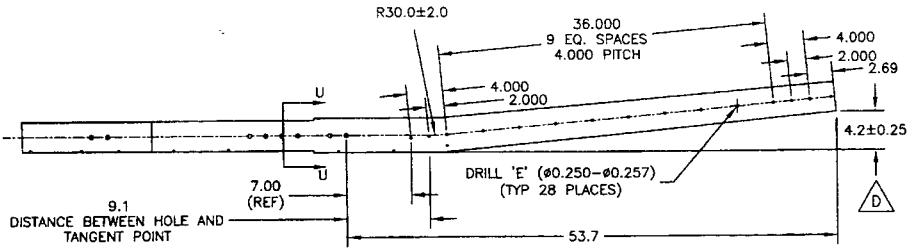


Copyright © 2008 by Paul A. Thompson, Inc.

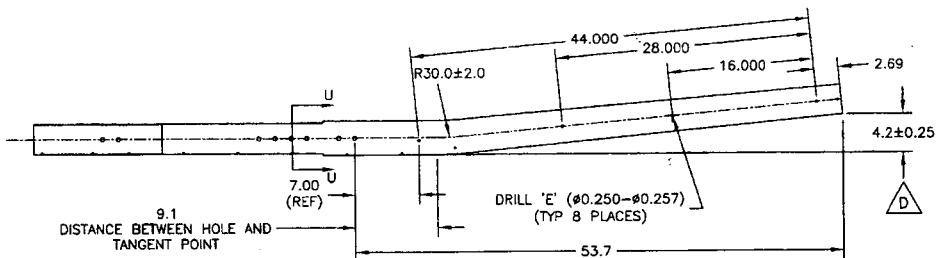
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED ✓	APPROVED ✓	DRAWING NO. D3391	REV. F	SHEET 3 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20		

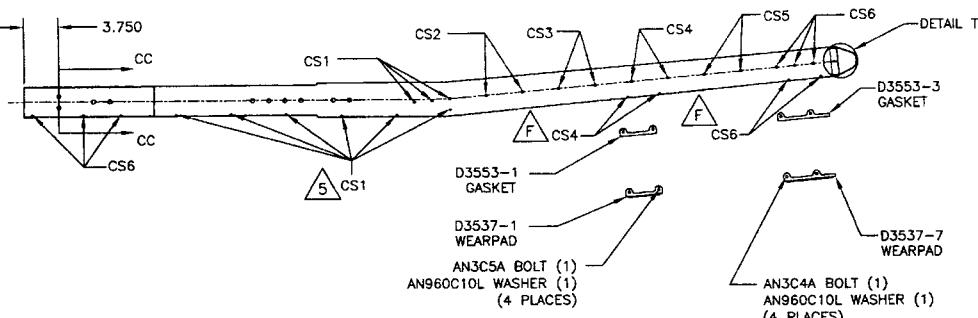




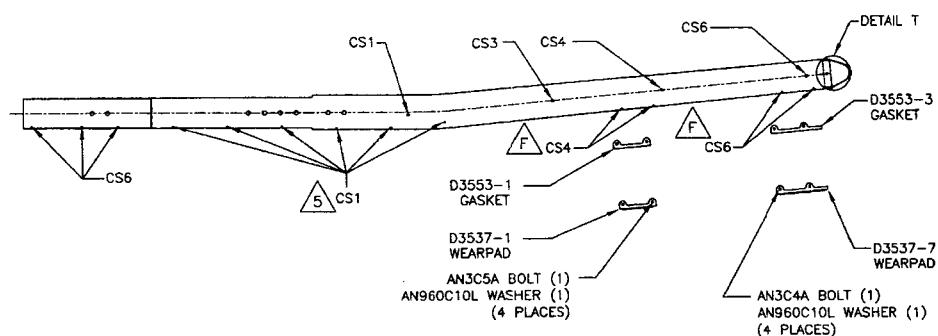
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



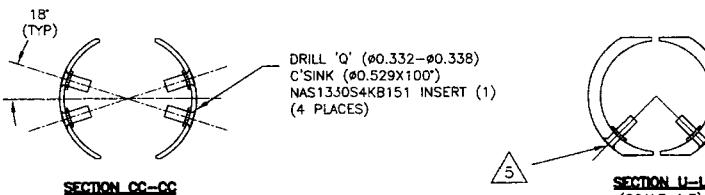
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
X	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
5	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

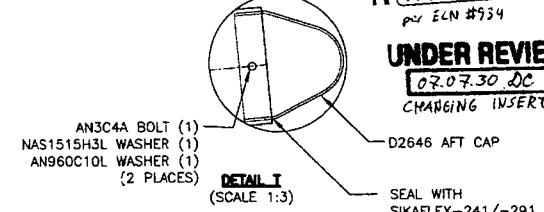
HOLES MARKED	QTY	QTY	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	18	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166



COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.		DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HEDDICK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3391		REV. F SHEET 5 OF 5	
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12			

RELEASED
07.03.13 AM
BY ELN #934

UNDER REVIEW
07.07.30 AM
CHARGING INSERTS



DETAIL T
(SCALE 1:3)